

Work Order ID 57071

Saturday, March 20, 2010 9:32:47 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long basket Ass'y, 350

Stop



Start Date: 3/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/31/2010 Req'd Qty: 1.00



Customer:

PRELIMINARY ISSUE

Reference:

Run Start



Approvals: Process Plan: UMF Date: 10-3-20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3913

~~DAT~~ Rev. A

100

Weld per dwg A/R S.S. rod Batch: H109215 0.00



Large Fab

Large Fab

Memo

0.00

1- assemble ribs, weld as per dwg D3913

PD 10.04.02

inspect before welding mesh

2- tack weld mesh on basket as per dwg D3913

3- weld hinge (3) and Mounting brackets as per dwg D3913 PD 10.04.02

take lid to locate hinge and bracket

PD / 10/04/03 (K)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

10.04.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Scobylou

inspect to "kw n" Day

PRESS WASH BR 10-4-5 D

BR 10-4-5

BR 10-4-5

D

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

S 10/04/05 @

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

S 10/04/06 @

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/04/06
To Rev A Pwg.

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Required Date: 3/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location:

0.00



Packaging

W/O 57139
Memo

0.00

Packaging

10/04/06

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/06

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

MMF

10-4-6

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 57071

Parent Item: D3913-041

Parent Item Name: Long basket Ass'y, 350


Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	35.0000	1.0000			

Warehouse Location

Location

Main Warehouse

WA

35

46086

2

48428

1

50872

1

51120






2

51745

2

55918

27

D3913-1  Rib		Manufactured	No			100	Each	0.0000	1.0000			
D3913-15  Wide Handle Plate		Manufactured	No			100	Each	0.0000	1.0000			
D3913-3  Rib		Manufactured	No			100	Each	0.0000	1.0000			
D3913-7  Rib		Manufactured	No			100	Each	0.0000	2.0000			
D3913-9  Rib		Manufactured	No			100	Each	0.0000	1.0000			

"Rev A"

Patern

"Rev A"

"Rev A"

Rev A

2x SH 10/04/01

B 57286 ① SH 10/04/01

B 57079 ① SH 10/04/01

B 57287 ① SH 10/04/01

B 57082 ② SH 10/04/01

B 57288 ① SH 10/04/01

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Required Date: 3/31/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3916-041  Rib Assembly		Manufactured	No			100	Each	0.0000	3.0000 2			
	"Rev A"									B 56941 ②	SY 10/04/01	
D3916-5  Light Rib		Manufactured	No			100	Each	0.0000	3.0000 3			
	"Rev A"									B 57023 ③	SY 10/04/01	
D4016-1  Hinge Half, Base		Manufactured	No			100	Each	0.0000	1.0000 3			
	"Rev A"									B 56949 ③	SY 10/04/01	
D4017-7  Rib		Manufactured	No			100	Each	0.0000	1.0000			
	"Rev A"									B 57084 ①	SY 10/04/01	
D4017-9  Rib		Manufactured	No			100	Each	0.0000	2.0000			
	"Rev A"									B 57085 ②	SY 10/04/01	
D4020-1  Mesh (350 Basket Long, Base)		Manufactured	No			100	Each	0.0000	1.0000			
	"Rev A"									B 56988 ①	SY 10/04/01	
D4020-11  End Mesh, Basket		Manufactured	No			100	Each	0.0000	1.0000			
	"Rev A"									B 56990 ②	SY 10/04/01	

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Shop Packet Print

Page 2

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Work Order ID: 57071

Parent Item: D3913-041

Parent Item Name: Long basket Ass'y, 350

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4021-1 Handle Plate		Manufactured	No			100	Each	3.0000	1.0000 3			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	3	
56044	3	

B57068 ③ J 10/04/01

D4034-041 Aft Upper Rib Assembly		Manufactured	No			100	Each	0.0000	1.0000			
D4034-043 Fwd Upper Rib Assembly		Manufactured	No			100	Each	0.0000	1.0000			
AN340A Bolt		Purchased	No			150	Each	56.0000	6.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST351	56	
111119	56	
111119		

B56991 ① J 10/04/01

B56992 ① J 10/04/01

⑥ J 10/04/05

Saturday, March 20, 2010 9:32:47 AM

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Page 3

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Page 4

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Parent Item: D3913-041



Parent Item Name: Long basket Ass'y, 350

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8 Washer		Purchased	No			150	Each	226.0000	1.0000			



NAS1149DN8325

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	4114108	
ST347	226	
107091	9	
108335	11	
110382	48	
110917	3	
111578	15	
112385	140	

2 ss 1064105

D2931 Bumper	Manufactured	No				150	Each	895.0000	1.0000			
---------------------	--------------	----	--	--	--	-----	------	----------	--------	--	--	--



Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST504	895	
46064	895	

2 ss 1064105

D4021-5 Blanking Plate	Manufactured	No				150	Each	0.0000	1.0000			
-------------------------------	--------------	----	--	--	--	-----	------	--------	--------	--	--	--



~~0571887~~ 57360

lev A

2 ss 1064105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W3 Cherry Rivets		Purchased	No			150	Each	2,319.000	1.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST321

2319

102929

37

104715

10

106375

304

107939

1000

111636

968

2 SB 10/04/05

MS21042L3

Purchased

No

150

Each

2,141.000

6.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

2141

110844

35

111274

27

111668

58

112314

285

112385

16

113523

20

113537

700

113644

1000

16 SB 10/04/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Long basket Ass'y, 350

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Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149F0332P		Purchased	No			150	Each	1,110.000	12.0000			
---------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST275

1110

18057

1110

12 80 03/04/05

Saturday, March 20, 2010 9:32:47 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

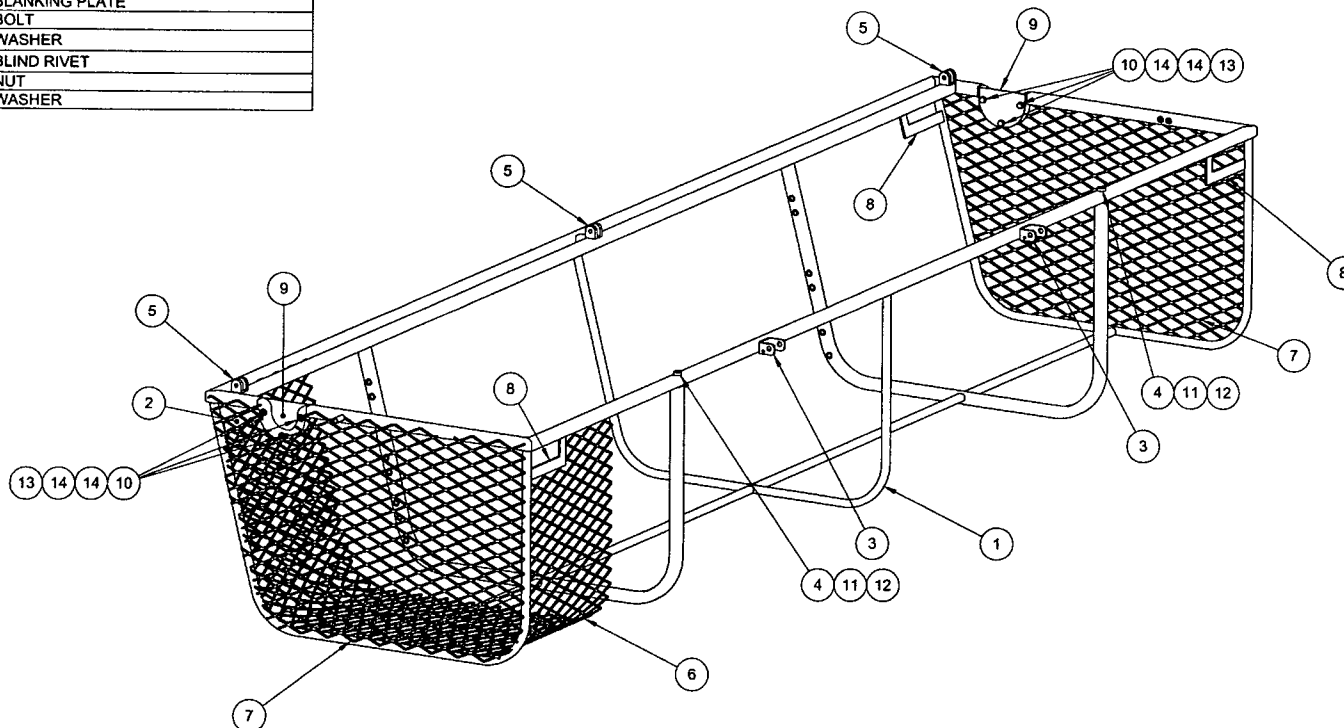
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	SHEET 1 OF 6
DRAWING NO. D3913		TITLE	SCALE
LONG BASKET BASE ASSY (350) NTS			
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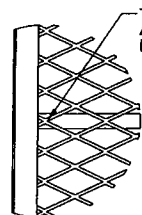
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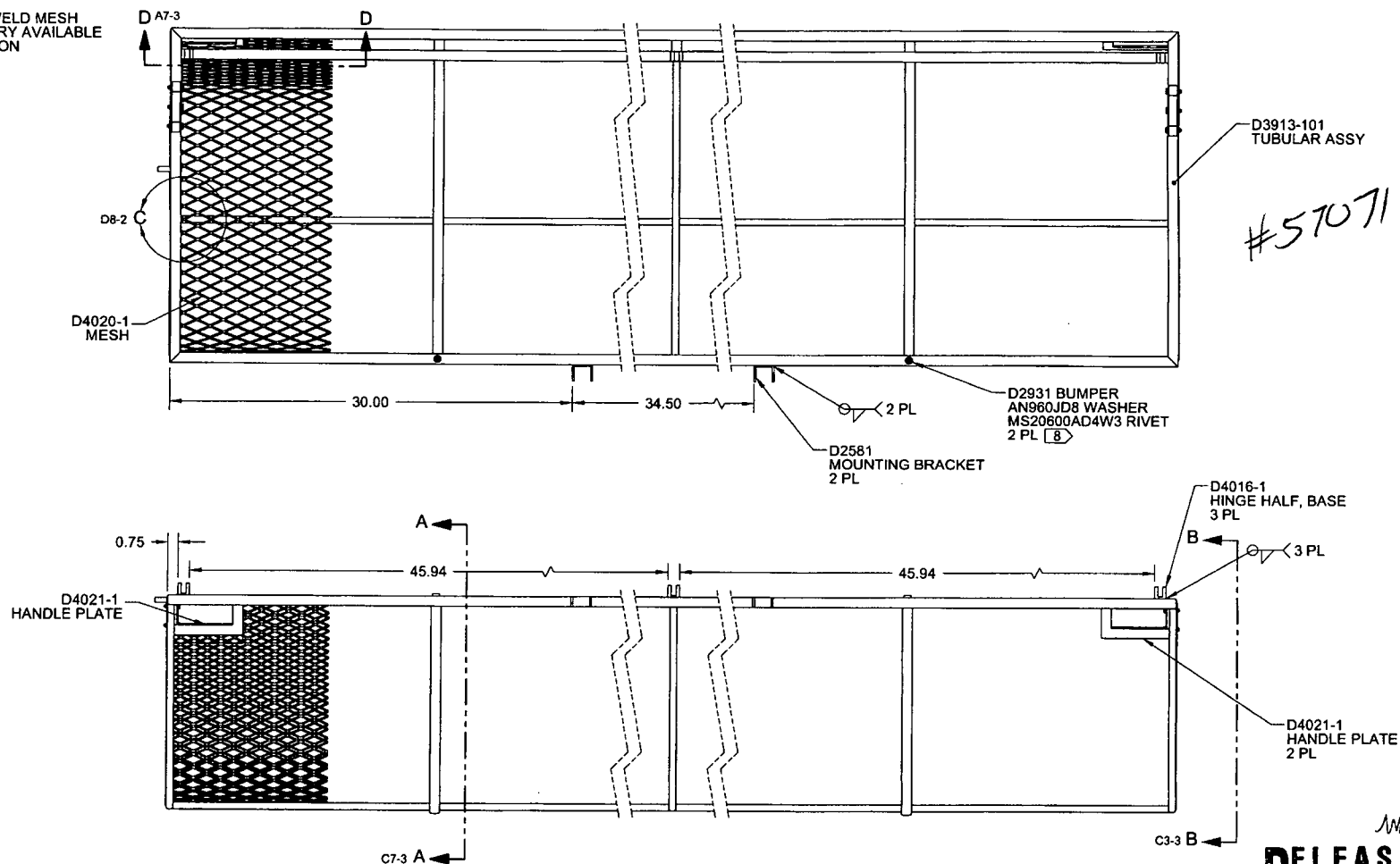
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NOTE: Date & initial all entries



DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-09-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

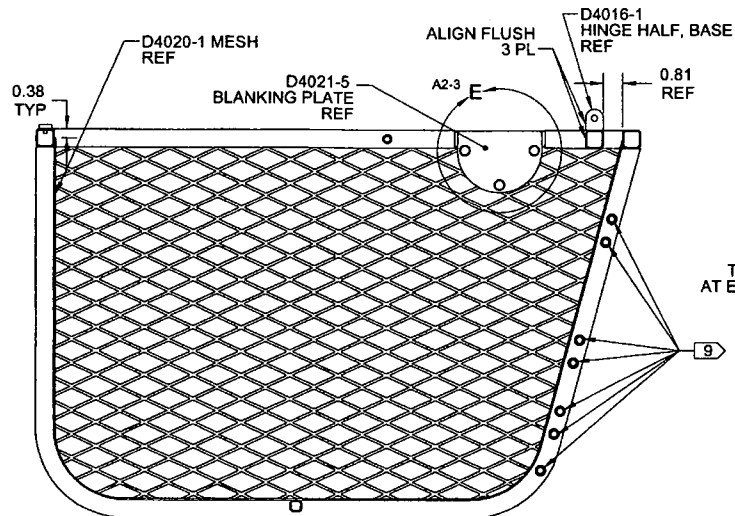
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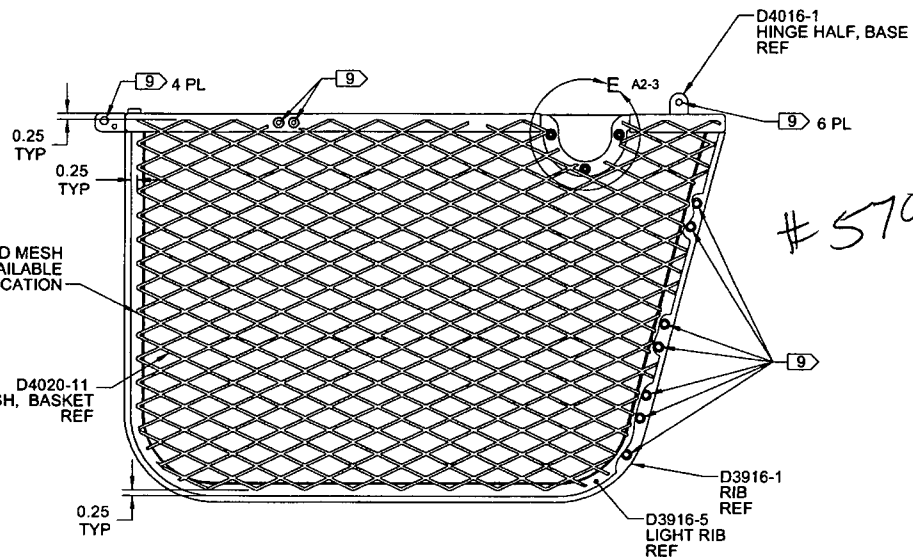
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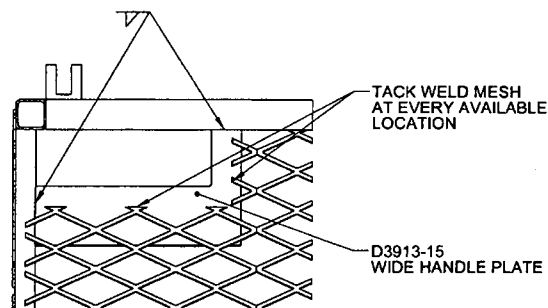
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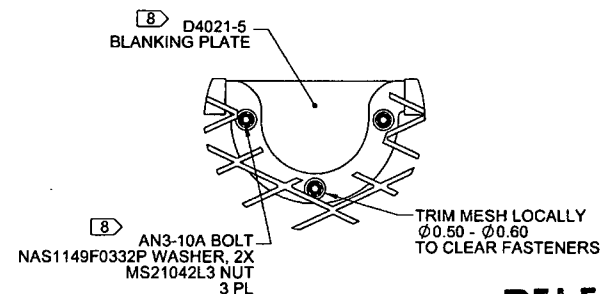
SECTION A-A A5-2







VIEW B-B A2-2



SECTION D-D 07-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

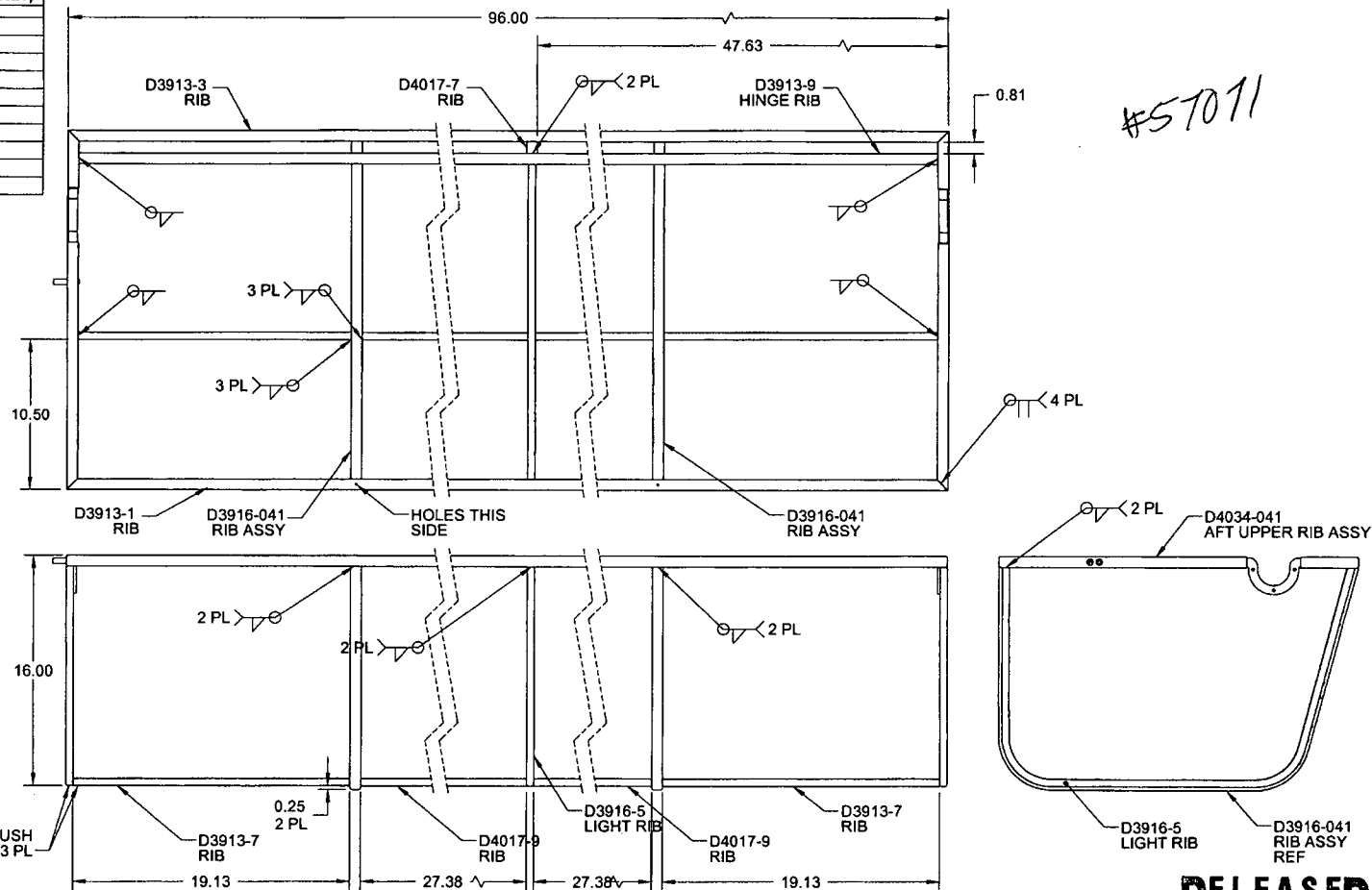
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
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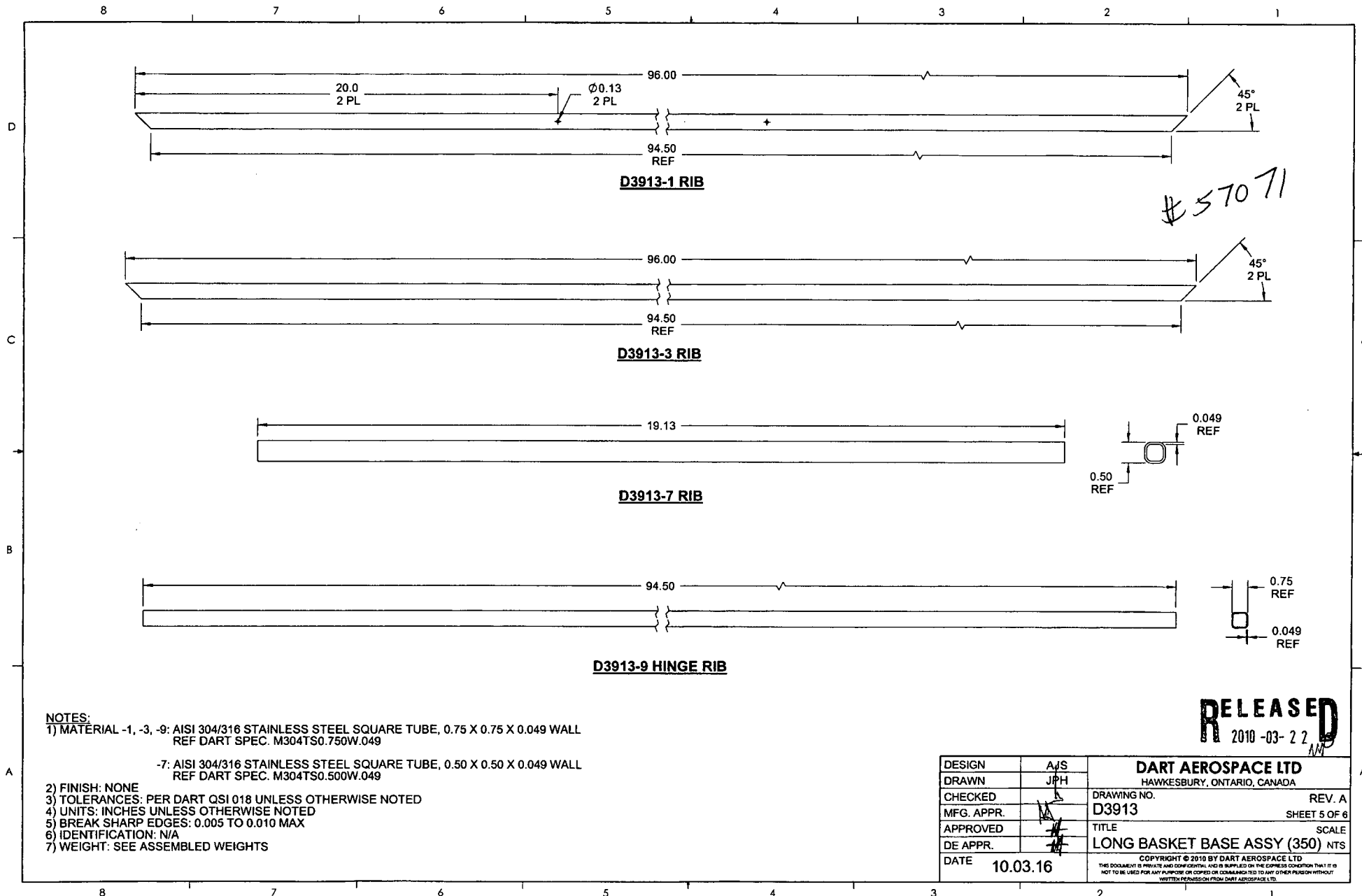
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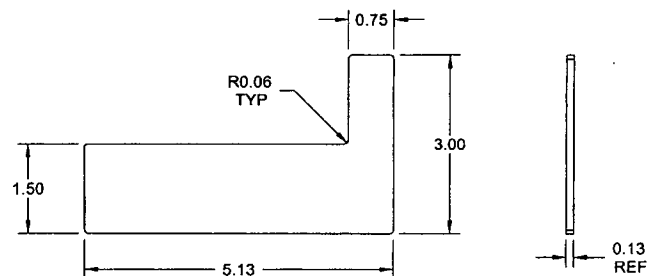
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#57071



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2010-03-22
JWP

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APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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